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12984

D3916-041 Job Sheet 189891



Part No: D3916-041

Job Qty: 6 ea

Part Name: Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/19

Job Tracking No:

Due Date: 2/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/15/19	2/15/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	6 pcs	2/15/19	2/15/19	0.00	2.94	Large Fab 8		
105	QC	6 pcs	2/15/19	2/15/19	0.00	0.00	QC5		
107	Large Fab	6 pcs	2/15/19	2/15/19	0.00	0.00	Large Fab 1		
110	QC	6 pcs	2/15/19	2/15/19	0.00	0.00	QC5		
120	QC	6 pcs	2/15/19	2/15/19	0.00	0.00	QC10		
130	Packaging	6 pcs	2/15/19	2/15/19	0.00	0.00	Packaging3 Large Fab		
140	QC21-SA	6 Ea	2/15/19	2/15/19	0.00	0.00	QC21		

Part Op 100 - 1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other
Descriptions: lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg
D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
107 - 1- weld bushing as per dwg D3916 2- grind welds flush
130 - LOCATION: WA004-5

M Unit #008855

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3759-1	Bushing	42 pcs (7 ea)	90-Start up Operation	5160918
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	24.9960 ft (4.166 ea)	90-Start up Operation	5160913

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3759-1	42	189	0
	M304TS0.750W.049	25	320	0

Part Specifications

Specifications could not be found.

ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



Container No: S166008

Part: D3916-041

Job No: 189891

Serial No/Batch: S166008

Revision:

Inspector:

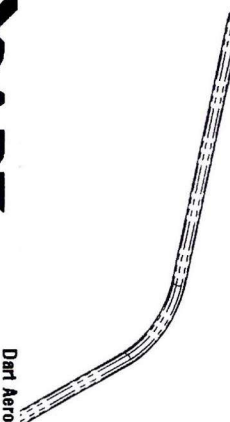
Exp Date:

Instructions: Various STC's

Date: 03/25/19

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AEROSPACE

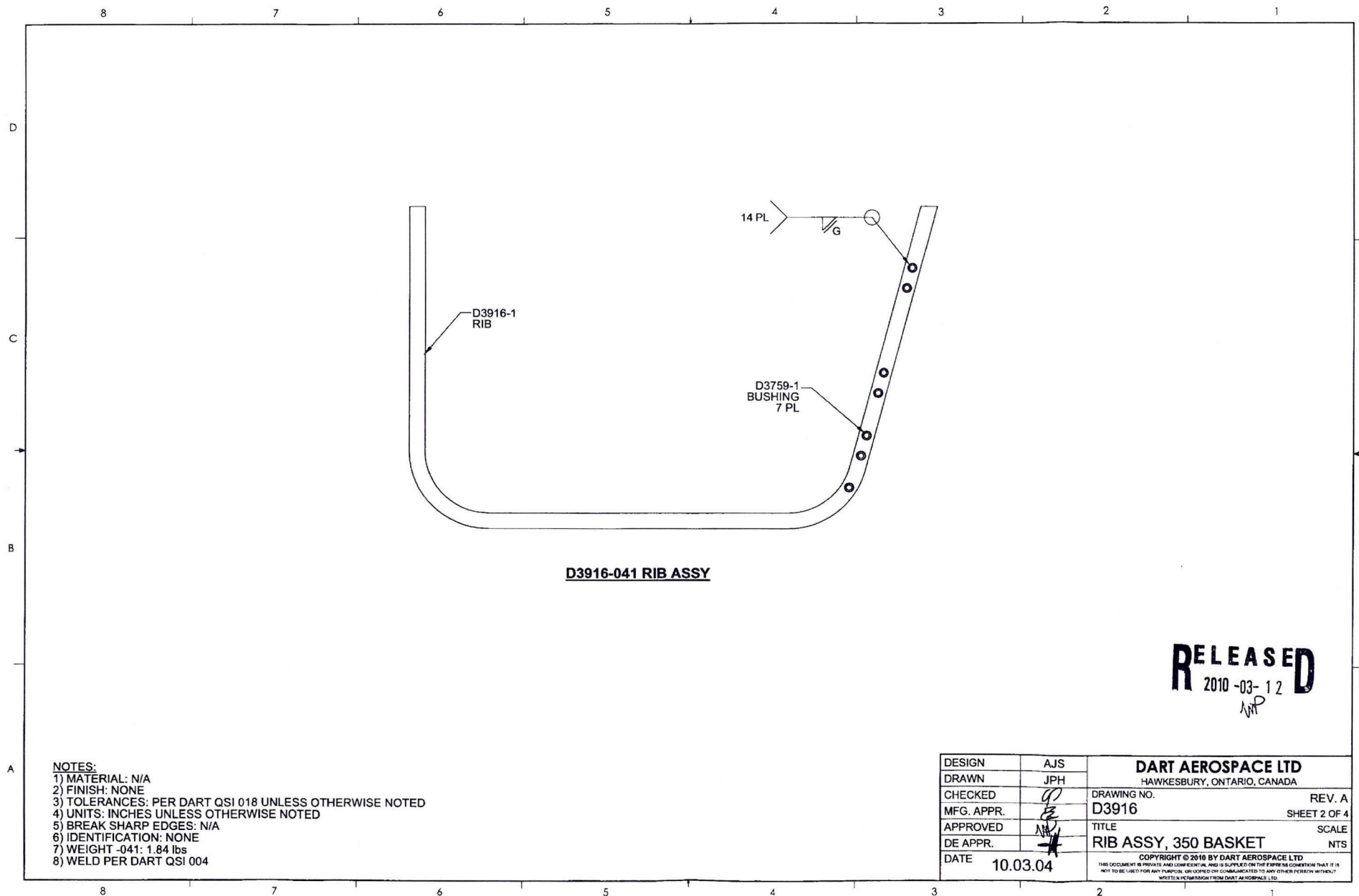
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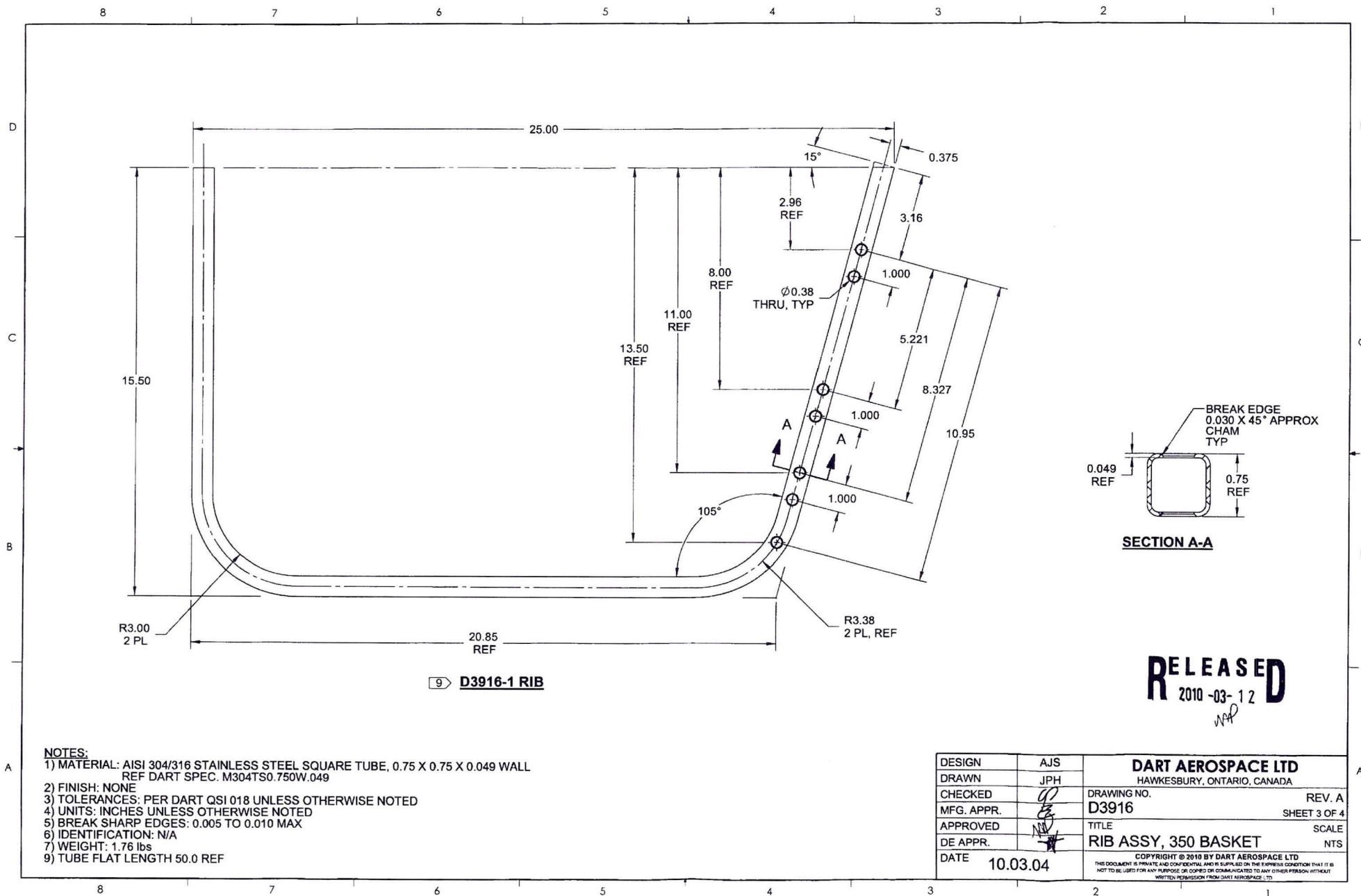


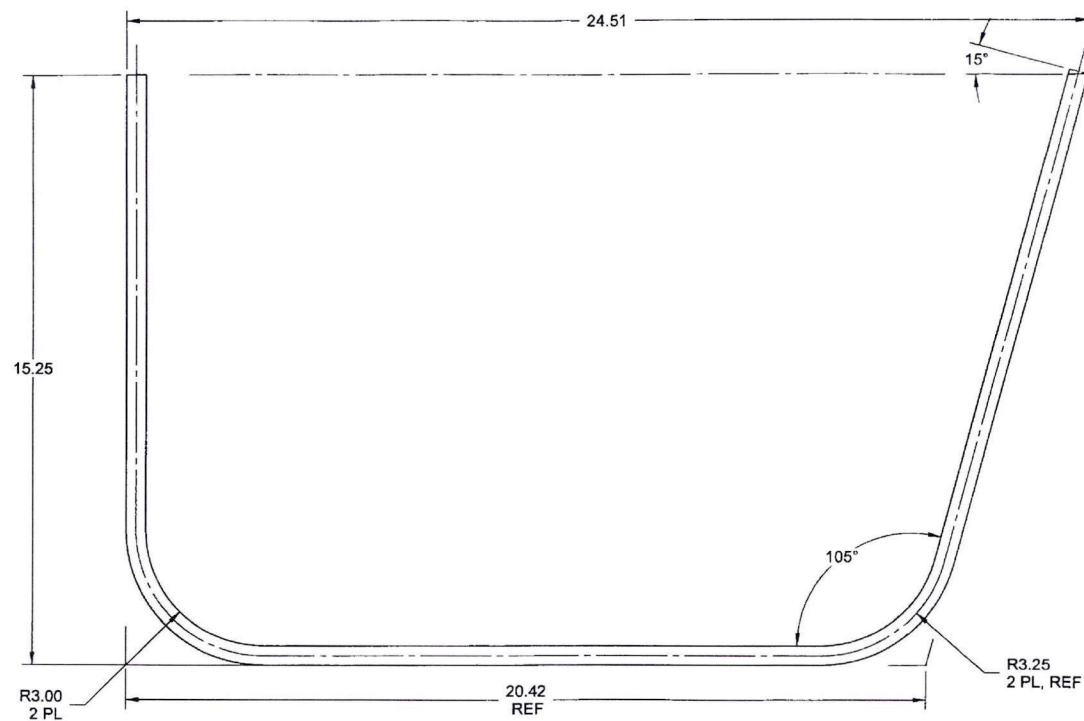
3 LIGHT RIB

OK 10.12.21
~~UNDER REVIEW~~
~~10.10.11~~
ADDITION OF HOLE + BUSHING
ON D3916-041-1 RIBS.
RELEASED
2010-03-12
JWP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	







9) **D3916-5 LIGHT RIB**

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	JE	D3916	SHEET 4 OF 4
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					